

Work Order ID 127404

127404

Page 1

December-17-14 1:22:43 PM

Item ID: D412-705-015 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Driveshaft Tunnel Modification 2
 Start Date: 12/15/14 Start Qty: 100 *1* Cust Item ID:
 Required Date: 12/19/14 Req'd Qty: 100 *1* Customer:
 Reference:

Approvals: Process Plan: MLS Date: 14-12-22 Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN-D412-750	E								
100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile & type labels per PPP D412-705-015								
	CHG 005								
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									
120	QC4-100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.00							
Quality Control									

2x

DAS
46
9-89

2

FEB 24 2015

DAS
63
9-89

2x

DAS
46
9-89

DAS
28
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Work Order ID 127404

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Item ID: D412-705-015 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Driveshaft Tunnel Modification
 Start Date: 12/15/14 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 12/19/14 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Packaging	0.00							
130									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D412-705-015 Location: <u>659</u> PPP Rev: _____								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

(2)

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46
9-89

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MCS 1502-24

MF
15-2-24

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear	General		
☐ Bending	☐ Bend	☐ Folio/Program	☐ Outside Dimensions
☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance
☐ Cracks	☐ Broken/Damage/Defect	☐ Hardware	☐ Part Incorrect
☐ Crimp/Kink/Ripple/Wave	☐ Burrs	☐ Inspection Incomplete/Unqualified	☐ Part Lost/Missing
☐ Cuffs	☐ Contamination	☐ Instructions Incomplete/Unclear	☐ Part Moved
☐ Crushing	☐ Countersink	☐ Misaligned/off center	☐ Positioned Wrong
☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Power Loss/Surge
☐ Inspection Strip in Tube	☐ Drawing	☐ Misread	☐ Pressure/Forced
☐ Marks/Chatter	☐ Drill Holes	☐ Off-set	☐ Set-up
☐ Turning Sequence	☐ Finish	☐ Out of Calibration	☐ Temperature/Cure
☐ Wave/Twist in Tube	☐ Fit/Function	☐ Out of Sequence	☐ Weld
			☐ Wrong Stock Pulled
			☐ Other

Picklist Print

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Work Order ID: 127404

127404

Parent Item: D412-705-015

D412-705-015

Parent Item Name: Driveshaft Tunnel Modification

Start Date: 12/15/14

Required Date: 12/19/14

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP Rev:B Removed Manufacturing 06-10-03 JLM
IPP Rev:C ECN 1052 07-11-05 DD verified by:EC
ECN 12-670 12.11.07 DD Verified by:JLM

IPP Rev:D

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN3C3A		Purchased	No			110	Each	405.0000	(22) 22 44				
AN3C3A									**	131618			
Bolt													
	DAS 46 9-89												
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				GA				81				DAS 63 9-89	DAS 28 9-89
				122141				6					
				124417				75					
				ST350				324					
				124417				324					
AN3C4A		Purchased	No			110	Each	646.0000	(3) 26				
AN3C4A									**	128879			
Bolt													
	DAS 46 9-89												
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				FG				20				DAS 63 9-89	
				122814				20					
				FP001				69					
				M130716				69					
				ST350				557					
				M130716				557					
D3256-1		Manufactured	No			110	Each	1.0000	(1) 12				
D3256-1									**	116806-X1			
Panel													
	DAS 46 9-89												
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST489				1				DAS 63 9-89	DAS 28 9-89
				100800				1					

FEB 24 2015

DQA: _____ Date: _____



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Doc/Data ☐									
Equip/Tooling ☐									
Handling/Pre ☐									
Material ☐									
Operator ☐									
Offset/Setup ☐									
Process ☐									
Supplier ☐									
Training ☐									
Transport ☐									
Unapproved ☐									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

December-17-14 1:22:42 PM

Work Order ID: 127404

127404

Parent Item: D412-705-015

D412-705-015

Parent Item Name: Driveshaft Tunnel Modification

Start Date: 12/15/14

Required Date: 12/19/14

Start Qty: 1.00

Required Qty: 1.00

D3256-3 Manufactured No 110 Each 0.0000

D3256-3 DAS 46

Gasket

MS20427M3-3

Purchased No

110 Each

1,941.000

(1) 1/2
** 116985

68-6
DAS
28
9-89

MS20427M3-3

DAS 46

Rivet

9-89

Location

Loc Qty

Loc Code

GA

109

m129864

109

ST311

1832

m130922

1832

110

Each

45.0000

(22) 22 44
** 113187

68-6
DAS
28
9-89

MS21060-L3K

Purchased

No

MS21060-L3K

DAS 46
9-89

Nut Plate

Location

Loc Qty

Loc Code

GA

42

m127836

42

ST302

3

m127836

3

110

Each

60.0000

(25) 25 50
** 113187

68-6
DAS
28
9-89

MS9321-09

Purchased

No

MS9321-09

DAS 46
9-89

Washer

Location

Loc Qty

Loc Code

ST273

60

m130358

60

FEB 24 2015

68-6
DAS
28
9-89

DQA: _____ Date: _____



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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
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Doc/Data ☐									
Equip/Tooling ☐									
Handling/Pre ☐									
Material ☐									
Operator ☐									
Offset/Setup ☐									
Process ☐									
Supplier ☐									
Training ☐									
Transport ☐									
Unapproved ☐									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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DART AEROSPACE LTD.

REFERENCE ONLY

DAS

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IIN-D412-705

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5.0 PARTS LIST

FEB 24 2015

Qty -011	Qty -013	Qty -015	Qty -017	Qty -019	Qty -021	Qty -023	Part Number	Description
X							D412-705-011	TWIN PAK E-Z ACCESS KIT
1	X						D412-705-013	INTAKE PLENUM ACCESS PANEL KIT
1		X					D412-705-015	DRIVESHAFT TUNNEL MODIFICATION KIT
1			X				D412-705-017	N1 GEARBOX ACCESS PANEL KIT
1				X			D412-705-019	C-BOX OIL COOLER LINE SUPPORT ACCESS KIT
1					X		D412-705-021	OIL PRESSURE TRANSMITTER ACCESS KIT
1						X	D412-705-023	OIL COOLER SUPPORT REMOVABLE LOWER PANEL KIT
	1						D3245-041	ACCESS PANEL ASSEMBLY, LH
	1						D3245-042	ACCESS PANEL ASSEMBLY, RH
	2						D3245-043	DOOR ASSEMBLY
	2						D3245-9	GASKET
	2						D3245-11	GASKET
	2						D3245-13	GASKET
			1				D3255-041	ACCESS PANEL ASSEMBLY, LH
			1				D3255-042	ACCESS PANEL ASSEMBLY, RH
							D3256-1	ACCESS PANEL
							D3256-3	GASKET
				1			D3259-041	ACCESS PANEL ASSEMBLY, LH
				1			D3259-042	ACCESS PANEL ASSEMBLY, RH
					1		D3307-041	ACCESS PANEL ASSEMBLY
						30	AN3-3A	BOLT
		22	30		6		AN3C-3A	BOLT
		3					AN3C-4A	BOLT
						30	AN960JD10	WASHER
16	44		36		12		MS20427M3-3	RIVET
						2	MS21051-L3K	NUT PLATE
8	22		18		6		MS21060-L3K	NUT PLATE
						18	MS21069-L3K	NUT PLATE
		25	30		6		IMS9321-09	WASHER

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 Date: 13.10.07